

Date: Thursday, 11/15/2007 1:27:17 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 35782	
Estimate Number : 12411	
P.O. Number : <u>N/A</u>	Part Number : D35011
This Issue : 11/15/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3501 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 35316	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 12/12/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>142</u> Um: <u>200</u> Each
Comment : Est Rev A New Issue 06-05-09 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0750	303 Round Bar .75"
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Comment: Qty.: 0.0831 f(s)/Unit Total : 16.6110 f(s) 17494 58PCS
 303 Round Bar .75"
 (M303R0750) M105710 → 7.0275 f(s) (was not in the computer)
 Batch: 106292 20 07/12/07 H.A 07/12/08

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA650 & DWG D3501,
 FOLIO REV: A
 DWG REV: A

2-DEBURR AS REQUIRED

20 07/12/07 H.A/ 07/12/08 142 (200)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/12/07 H.A/ 07/12/08 142 (200)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

20 07/12/10 142 (200)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST705

20 11/14/12 (142)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3501-1 PAR #: N/A Fault Category: Prod / machined parts NCR: Yes No DQA: Date:

QA: N/C Closed: H Date: 07.12.13

NCR: <u>35782</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/10	#	58 parts were made using the wrong mat. (17-4 instead of 303). R.C. Employee pulled it.	<p>CP</p> <p>07.12.09 PV 081042</p>	<p>Parts OK OK. SCRAP</p> <p>Stock is different than batch No.</p> <p>07.12.09</p>	<p>H.A</p> <p>07/12/10</p>	<p>↓</p> <p>07/12/10</p>	<p>CP</p> <p>07.12.09 PV 081042</p>	<p>↓</p> <p>07/12/10</p>
		wrong mat. saw only a batch # on it. parts make mistake.		no replace.				

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 35782

Part Number: D35011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(142)

Comment: FINAL INSPECTION/W/O RELEASE

07/12/13

Job Completion



min 2007/12/12 CY

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

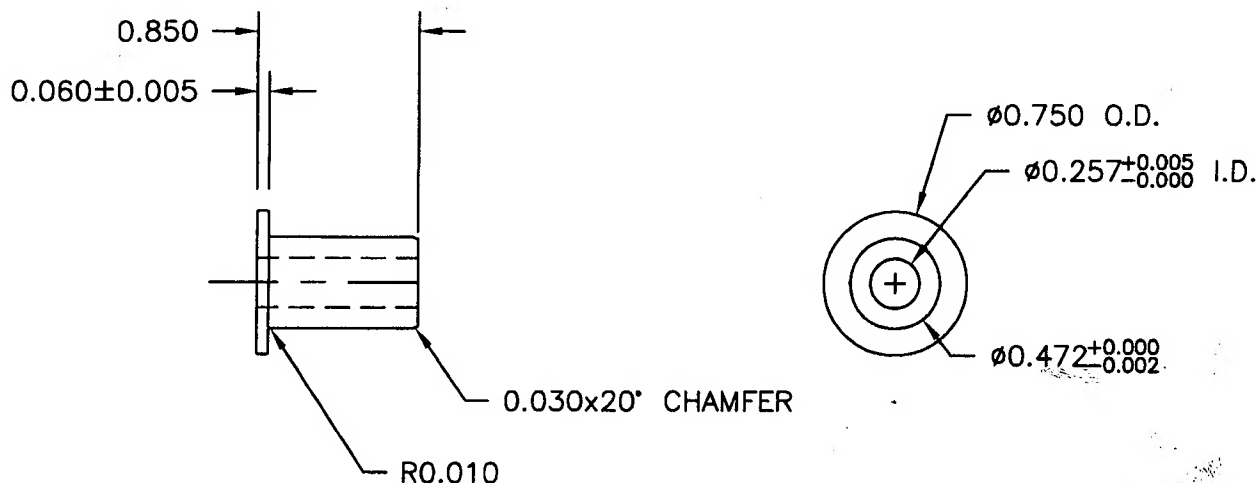
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3501	REV. A SHEET 1 OF 1
DATE 06.04.18		TITLE BUSHING	SCALE 1:1
A	06.04.18	NEW ISSUE	

PH/7-4

**D3501-1 BUSHING**

- 1) MATERIAL: AISI 303 SS (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMACHINED SHARP CORNERS 0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35782

RELEASED
06.08.15 H

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